

Date: Thursday, 2/7/2008 10:51:43 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING BRACKET
Job Number	: 37268		
Estimate Number	: 12473		
P.O. Number	:	Part Number	: D3246041
This Issue	: 2/7/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3246 REV A1
First Issue	: 1/1	Project Number	: N/A
Previous Run	: 36939	Drawing Revision	: A1
		Material	:
		Due Date	: 2/20/2008
Written By	:	Qty:	10
Checked & Approved By	:	Um:	Each
Comment	: Est Rev: A New Issue 06-06-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M2024T3S050	2024-T3 .050 sheet
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Comment: Qty.: 0.3252 sf(s)/Unit Total: 3.2519 sf(s)
 2024-T3 .050 sheet
 Material: 2024-T3 (QQ-A-250/4) 0.050" thick
 (M2024T3S.050)
 Identify for D3246-1 Batch: 105646 IB 8-2-11

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg Dsi9279
 Dwg Rev: A1
 Prog Rev: A1

IB 8-2-11



2-Deburr if necessary IB 8-2-11

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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IB 8-2-11



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/02/11 (12)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr
 Form as per Dwg D3246
 C'sink as per Dwg D3246

SB 08/02/21
MF 08-02-21

(12)

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: MOUNTING BRACKET

Job Number: 37268

Part Number: D3246041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Handwritten: 08-2-25 (12)



Comment: INSPECT WORK TO CURRENT STEP

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: FZ 08/02/26 (12)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Handwritten: RS



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-02-26 (X12)

9.0

MS20426AD33

Rivet



Comment: Qty.: 8.0000 Each(s)/Unit Total: 80.0000 Each(s)

Rivet

Pick:

Qty Part Number Description Batch

8 MS20426AD3-3 Rivet

Handwritten: 1563

Handwritten: 10

10.0

MS21059L3

Nut Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Nut Plate

Pick:

Qty Part Number Description Batch

4 MS21059L3 Nut Plate

Handwritten: 106012

Identify as D3246-041

Handwritten: 12/8/26 (12)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plates as per Dwg D3246

Handwritten: 08/02/27 (10)

Handwritten: PTP

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08/02/27 (10)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3246-041 PAR #: NA Fault Category: Prod / ~~Ass~~ med & Small NCR: Yes No DQA: D Date: 08/01/26
 QA: N/C Closed: TD Date: 08/02/27

NCR: <u>37268</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08/02/27</u>	<u>11</u>	<u>2 pieces were snap counter sink new too deep</u>	<u>[Signature]</u>	<u>Scrap & destroy Nonepiece</u>	<u>[Signature]</u> <u>08/02/27</u>	<u>803</u> <u>08/02/27</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries

Date: Thursday, 2/7/2008 10:51:43 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 37268

Part Number: D3246041

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 221

ST 79

PC 8/4/27

(10)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

D 08/02/27

Job Completion



U 08/02/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

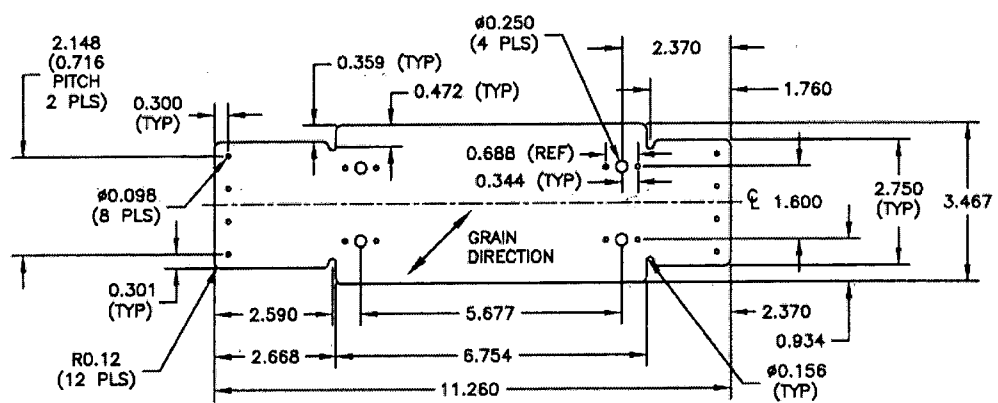
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

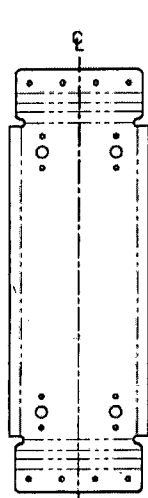


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21		TITLE MOUNTING BRACKET	SCALE 1:4
A	04.04.21	NEW ISSUE	
A1	04.06.16	CHANGE RIVET; ADDED C'SINK	

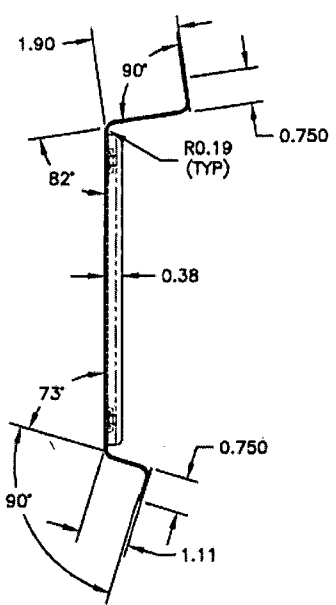
RELEASED
04.05.07 *[Signature]*



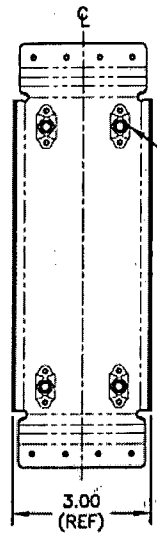
D3246-1 FLAT PATTERN



D3246-1 BEND DETAIL



D3246-041 ASSEMBLY



MS21059-L3
NUT PLATE (1)
MS20470AD3-4 RIVET (2)
(4 PLACES)
INSTALL AFTER
ALODINE
C'SINK 70.185 X 100°
MS20426AD3-3 RIVET (2)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37268

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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